



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-024
Job Sheet 193531



Part No: D350-636-024

Job Qty: 1 ea

Part Name: AS350/355 - Skidtubes - Standard w/ Heavy-Duty Wearplates - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/16/19

Job Tracking No:

Due Date: 4/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D4168-052 REV.C, IIN-D350-636 REV.K IPP REV.A 18.11.29 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S174641



Part: D350-636-024

Job No: 193531

Serial No/Batch: S174641

Revision: C/K

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17 T&C STC SH99-7 Issue 2 FASA STI

S174641RH

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/30/19	4/30/19	0.00	0.00	Start Up Skid tubes-1		BE
110	Skid tubes	1 pcs	4/30/19	4/30/19	0.00	4.78	Skid tubes-1		BE
120	QC	1 pcs	4/30/19	4/30/19	0.00	0.00	QC10		CPL DAS
130	QC	1 pcs	4/30/19	4/30/19	0.00	0.00	QC5		MAY 01 2019 68
140	HandFinish	1 pcs	4/30/19	4/30/19	0.00	0.98	HandFinish1		DR 17/05/2019
150	QC	1 pcs	4/30/19	4/30/19	0.00	0.00	QC7-2		AGG
160	Skid tubes	1 pcs	4/30/19	4/30/19	0.00	4.78	Skid tubes-1		DO BE TF
170	QC	1 pcs	4/30/19	4/30/19	0.00	0.00	QC10		CPL
180	QC	1 pcs	4/30/19	4/30/19	0.00	0.00	QC5		CPL
190	HandFinish	1 pcs	4/30/19	4/30/19	0.00	0.98	HandFinish2		MAY 27 2019
200	SprayPaint	1 pcs	4/30/19	4/30/19	0.00	0.61	Spray Paint		AS 19-5-28
205	Outsource	1 pcs	4/30/19	4/30/19			ATE003-VC	5	NR
210	QC	1 pcs	4/30/19	4/30/19	0.00	0.00	QC14		U 14-6-4
230	HandFinish	1 pcs	4/30/19	4/30/19	0.00	0.98	HandFinish4		U 14-6-20
240	QC	1 pcs	4/30/19	4/30/19	0.00	0.00	QC5		vm DAS 6-26
250	Packaging	1 pcs	4/30/19	4/30/19	0.00	0.00	Packaging1-3		DAS 28
260	QC	1 pcs	4/30/19	4/30/19	0.00	0.00	QC4		9-89
270	Packaging	1 pcs	4/30/19	4/30/19	0.00	0.00	Packaging3-1		JUL 11 2019
275	DC	1 pcs	4/30/19	4/30/19	0.00	0.00	DC		21 DAS JUL 11 2019
280	QC21-FG	1 Ea	4/30/19	4/30/19	0.00	0.00	QC21		9-89 21 JUL 11 2019

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D4168-6 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 (D4168-6 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section DK-DK and open to 0.500" 5- Drill tow ring hole using DT9616 detail "DF" 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 7- Open up holes of Detail DF to 0.297" (total of 2 holes per side) +.201" (total of one hole per side DT9616) as per dwg D4168. 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 138988
 9- Grind welds flush as per Dwg D4168
 10- Open up holes using hole saw of Detail DG and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168. 4-Chamfer holes of Detail DG, ground handling and float holes per dwg D4168 (welding instructions on sheet) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 517432 exp. date: 08/12/19**ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D4168 & QSI004 (welding instructions on sheet) A/R Aluminum Rod batch: 139011 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section ES-ES (total of 4 places per side) as per dwg D4168 12- C'bore section ET-ET. ADJUST TOOLING AS REQUIRED. VERF BY: 13- Deburr holes, ensure tube is free of all scratches before sending to paint. ***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE *****
 *****REF TO W/O BATCH:*****
 180 - ***VERIFY C'BOARD IS GOOD***
 190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
 200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5179552 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5184740
 210 - Inspect for foreign object per QSI 024
 230 - 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: 5174342 EXP DATE: 14-12-19 5- Coat all exposed fasteners with "LPS Procyon" batch: 14133690
 250 - If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A
 260 - *****ensure antiseize is on AN8C21A bolts*****
 270 - Identify and pack for shipping as per PPPD350-636-024 Location : FG071
 275 - record fwd angle: 89.7 Photocopy blue file and type labels per PPP D350-636-024 CHG 001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	90-Start up Operation	010154
D2744	Cap	1 pcs (1 ea)	90-Start up Operation	5166246
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes	5150291
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes	5176881
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-HandFinish	5156521
AN3C34A	Bolt	1 Ea (1 ea)	230-HandFinish	5167517
AN3C36A	Bolt	4 Ea (4 ea)	230-HandFinish	5186091-1
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	FM137074-1-2
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5174235
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	5176396
D2745	Bushing	8 pcs (8 ea)	230-HandFinish	5167090
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-HandFinish	5188181
D3631-1	Washer	8 pcs (8 ea)	230-HandFinish	5179461
D3873-1	Bushing	7 pcs (7 ea)	230-HandFinish	5181110
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-HandFinish	5185770
D4170-1	Bushing	4 pcs (4 ea)	230-HandFinish	5191309
D4171-1	Bushing	1 pcs (1 ea)	230-HandFinish	5137508
MS21043-3	Nut	5 Ea (5 ea)	230-HandFinish	5147731
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5099269
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5181772
NAS1149C0332R	Washer	4 Ea (4 ea)	230-HandFinish	5167203-1
NAS1149C0363R	Washer	9 Ea (9 ea)	230-HandFinish	5158070
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	5185100
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5076017-2
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging	5083309
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	5162124
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging	5160967
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5159549
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5167203
				5166718

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-RH	1	6	0
	D2744	1	23	0
160-Skidtubes	D2739	1	10	0
	D2743	8	151	0
230-HandFinish	ALS4-1032-225	4	1,280	0
	AN3C34A	1	12	0
	AN3C36A	4	351	0
	AN3C6A	4	218	0
	AN6C44A	4	132	0
	AN8C35A	1	62	0
	D2745	8	168	0
	D3488-4	1	2	0
	D3631-1	8	213	0
	D3873-1	7	76	0
	D4154-041	1	0	0
	D4170-1	4	38	0
	D4171-1	1	8	0
	MS21043-3	5	1,090	0
	MS21043-6	4	158	0
	MS21083C8	1	332	0
	NAS1149C0332R	4	3,957	0
	NAS1149C0363R	9	493	0
	NAS1149C0832R	1	340	0
	NAS1515H3L	4	358	0
250-Packaging	AN3C37A	1	84	0
	AN8C21A	2	85	0
	D2741	1	63	0
	MS21083C8	2	332	0
	NAS1149D0863J	2	585	0

Part Specifications

Specifications could not be found.

Plex 4/16/19 11:25 AM Dart.lajeunesse.marie

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X					D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X				D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X			D4168-044	350 SKIDTUBE ASSEMBLY, RH
				X		D4168-051	350 SKIDTUBE ASSEMBLY, LH
					X	D4168-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1	1	1	1	1	1	D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG ASSEMBLY
8	8					D3492-043	PLUG ASSEMBLY
		8	8			D3492-045	PLUG ASSEMBLY
8	8	8	8	8	8	D3631-1	WASHER
7	7	7	7	7	7	D3873-1	BUSHING
1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1						D4168-1	SKIDTUBE WELDMENT, LH
	1					D4168-2	SKIDTUBE WELDMENT, RH
		1				D4168-3	SKIDTUBE WELDMENT, LH
			1			D4168-4	SKIDTUBE WELDMENT, RH
				1		D4168-5	SKIDTUBE WELDMENT, LH
					1	D4168-6	SKIDTUBE WELDMENT, RH
4	4	4	4	4	4	D4170-1	SPACER
1	1	1	1	1	1	D4171-1	BUSHING
4	4	4	4	4	4	ALS4-1032-225	INSERT
1	1	1	1	1	1	AN3C34A	BOLT
4	4	4	4	4	4	AN3C36A	BOLT
4	4	4	4	4	4	AN3C38A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
5	5	5	5	5	5	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
4	4	4	4	4	4	NAS1149C0332R	WASHER
9	9	9	9	9	9	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D4168-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.3
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 lbs
D4168-051/-052 = 31.9 lbs
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193531 MW
19-04-16

C	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-18); ADDED D4168-5/-6 (ZN B5-1, SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11, D2-12, D2-13, D2-14); ADDED NOTES 13, 14 (ZN C4-1); NAS1149C0363R WAS AN960C10 (ZN A5-1, C6-11, C7-11, D8-11, C6-12, C7-12, D8-12, C6-13, C7-13, D8-13, C6-14, C7-14, D8-14); NAS1149C0332R WAS AN960C10L (ZN B1-11, B1-12, B1-13, B1-14); NAS1149C0832R WAS AN960C818L (ZN C1-11, C1-12, C1-13, C1-14)	ZF	18.03.01
B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	DS		
DATE	18.03.01		

DART AEROSPACE USA, INC.

EUGENE, OR

DRAWING NO.

D4168

REV. C

SHEET 1 OF 18

TITLE

350 SKIDTUBE ASSEMBLY

SCALE

NTS

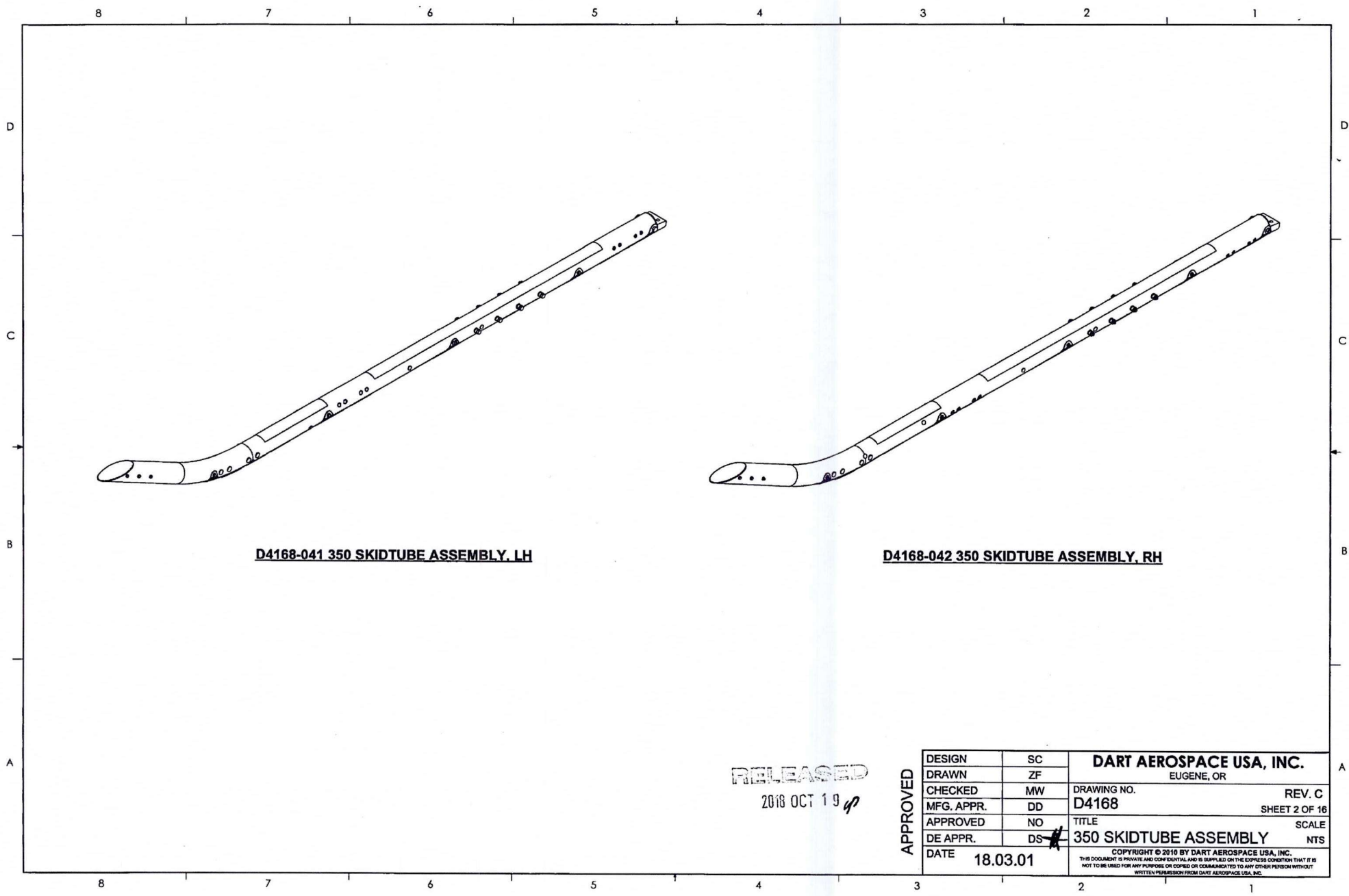
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RELEASED

2019 OCT 19

2019-03-03

APPROVED



D4168-041 350 SKIDTUBE ASSEMBLY, LH

D4168-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2018 OCT 19 *ap*

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 2 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

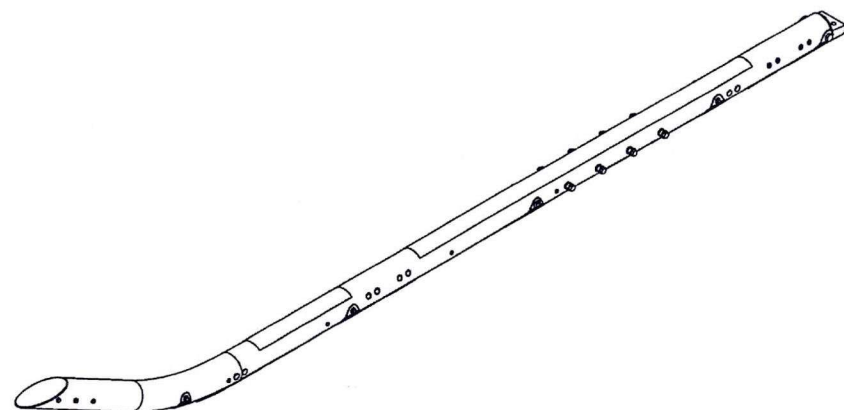
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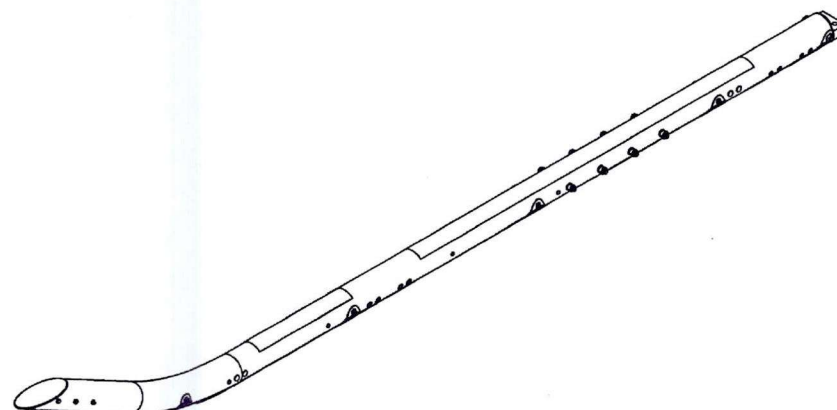
C

B

A



D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH

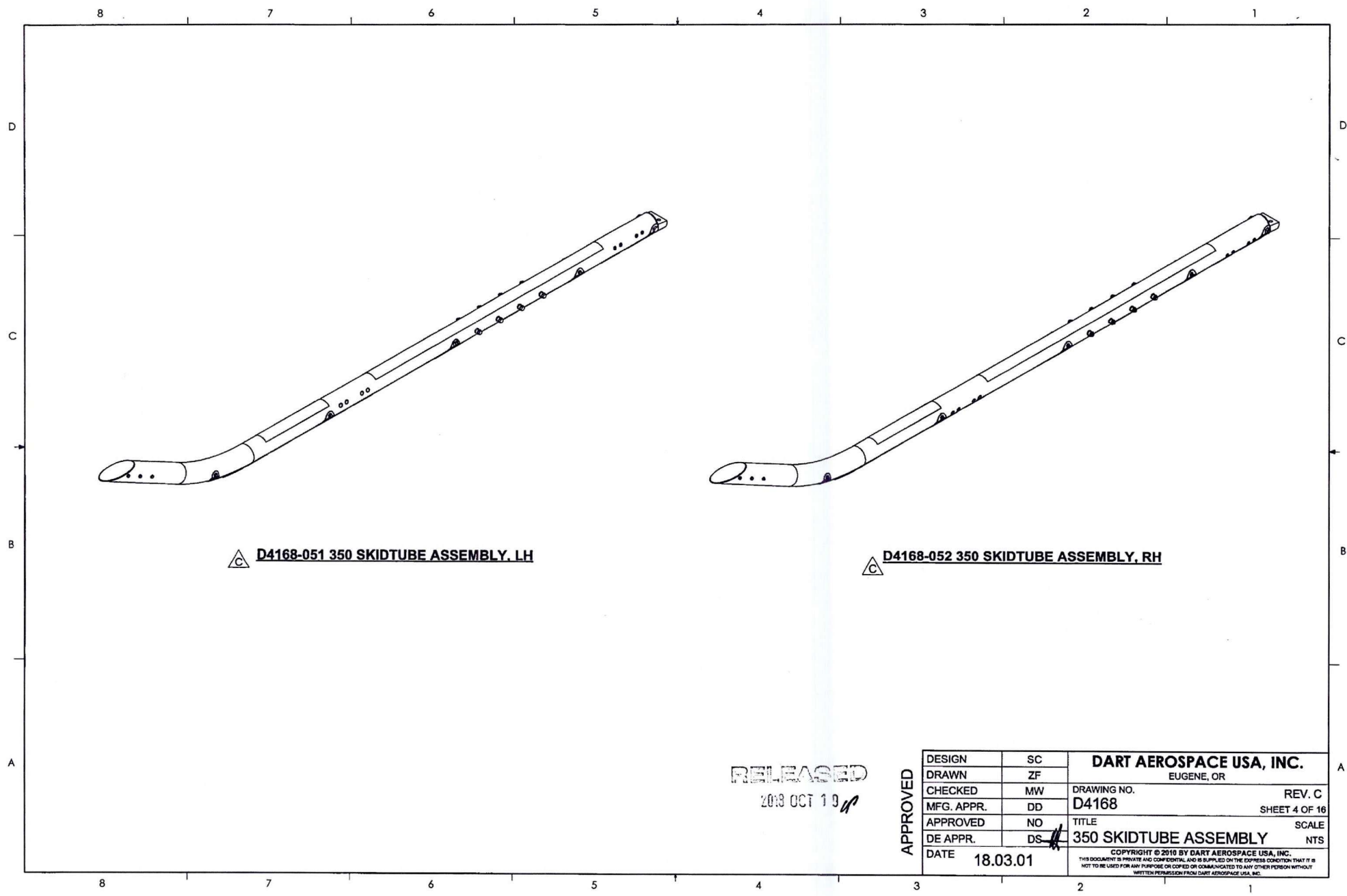
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2018 OCT 19 *up*

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MFG. APPR.	DD	D4168	SHEET 3 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D4168-051 350 SKIDTUBE ASSEMBLY, LH

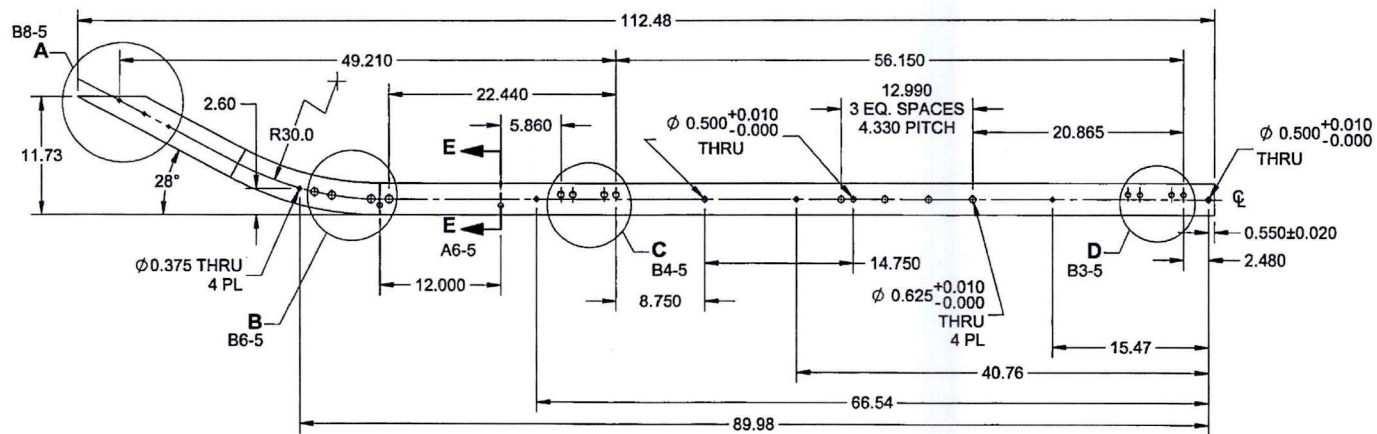
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2013 OCT 10

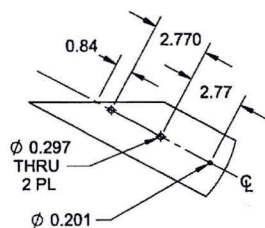
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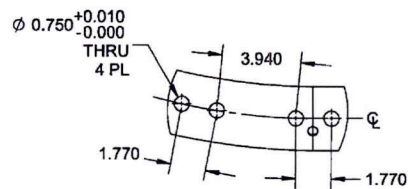
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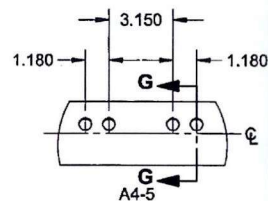
D4168-1 LH SKIDTUBE



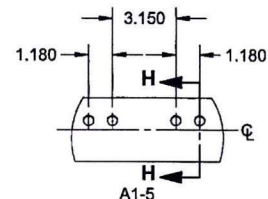
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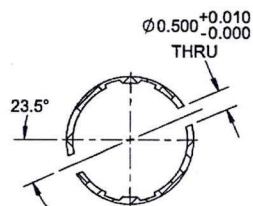
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C7-5
SCALE 2X



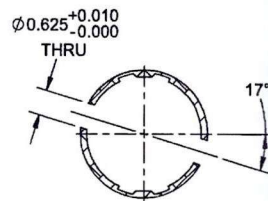
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D5-5
SCALE 2X



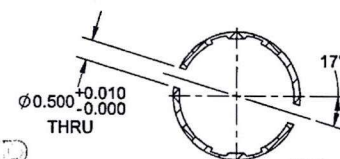
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SCALE 2X



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SCALE 4X, 2 PL



SECTION G-G
B4-5
SCALE 4X, 4 PL

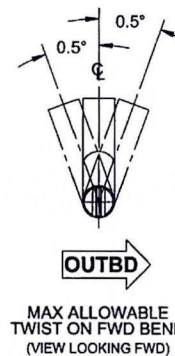
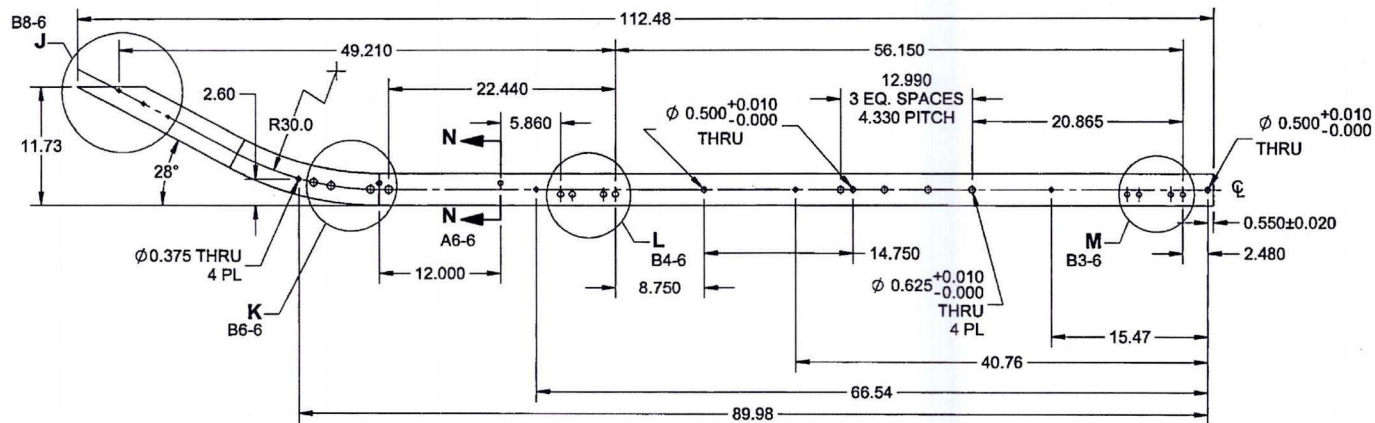


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B3-5
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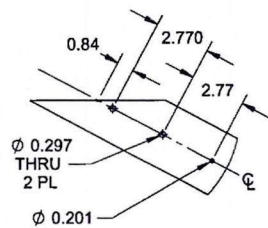
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2019 OCT 19

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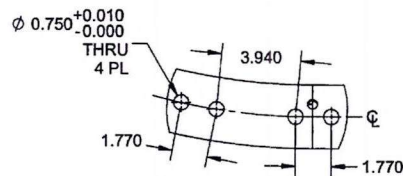
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APPROVED	NO	TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.	DS		
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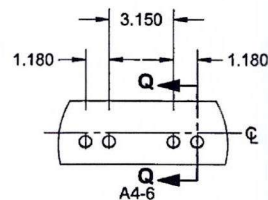
D4168-2 RH SKIDTUBE



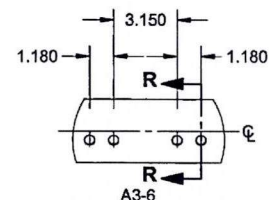
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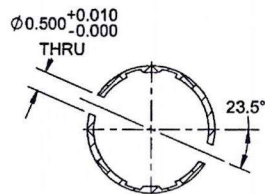
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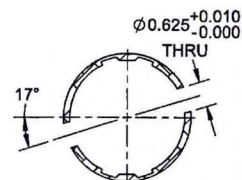
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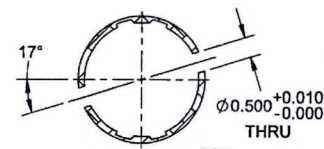
DETAIL M
SCALE 2X



SECTION N-N
SCALE 4X, 2 PL



SECTION Q-Q
SCALE 4X, 4 PL



SECTION R-R
SCALE 4X, 4 PL

APPROVED

DESIGN	SC
DRAWN	ZF
CHECKED	MW
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS
DATE	18.03.01

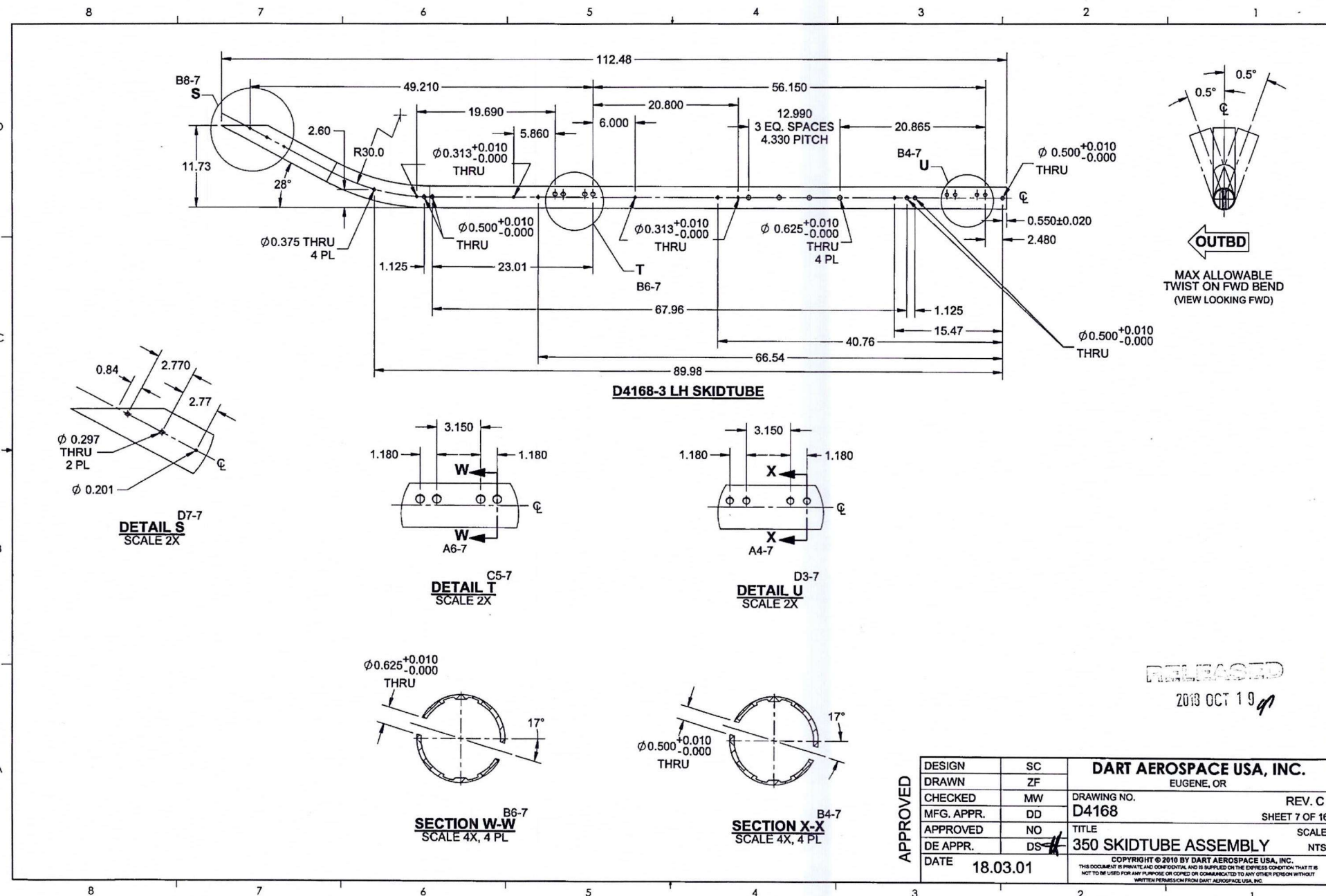
DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. **D4168** REV. C
SHEET 6 OF 16
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

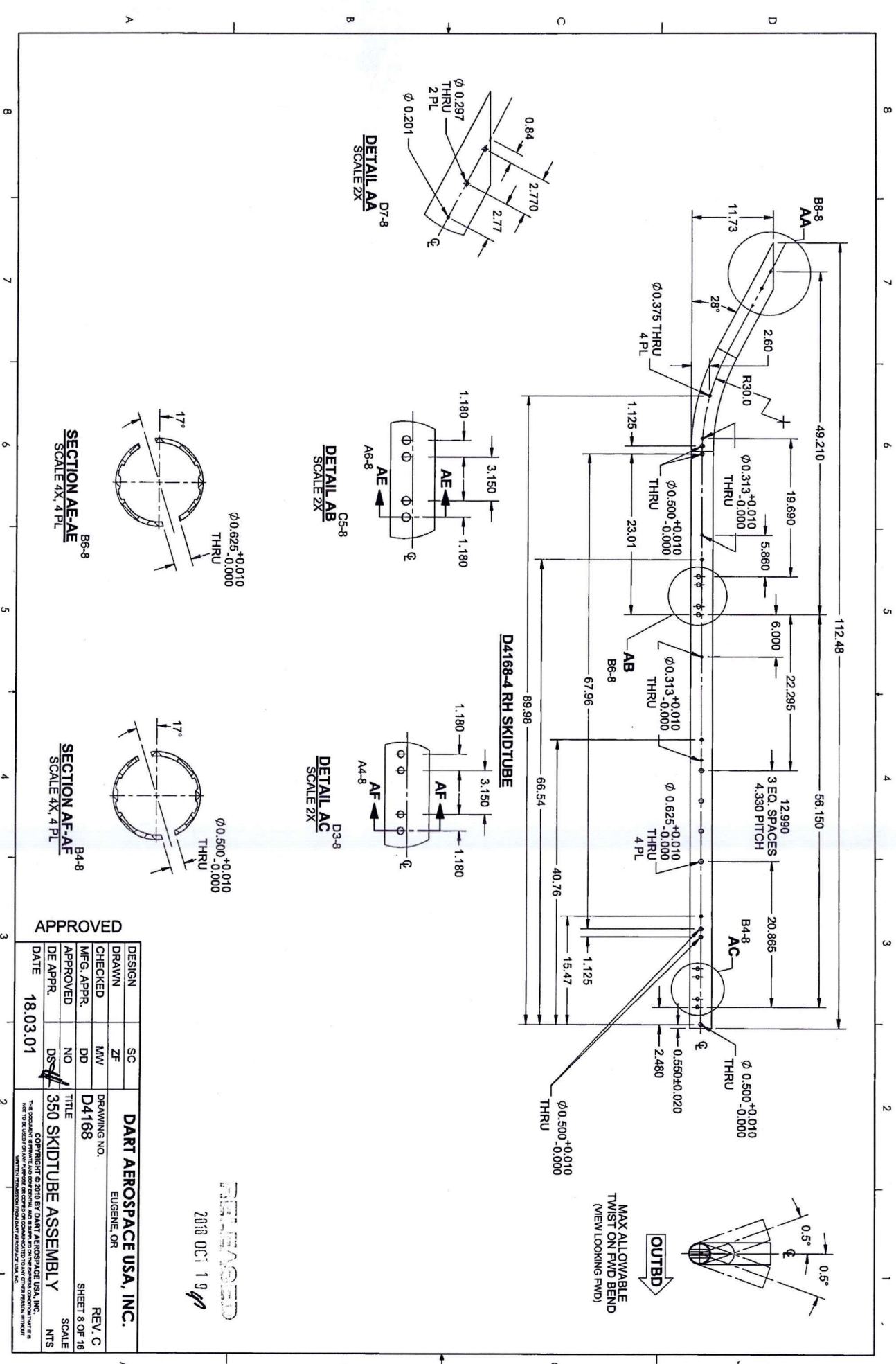
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RELEASED

2010 OCT 19

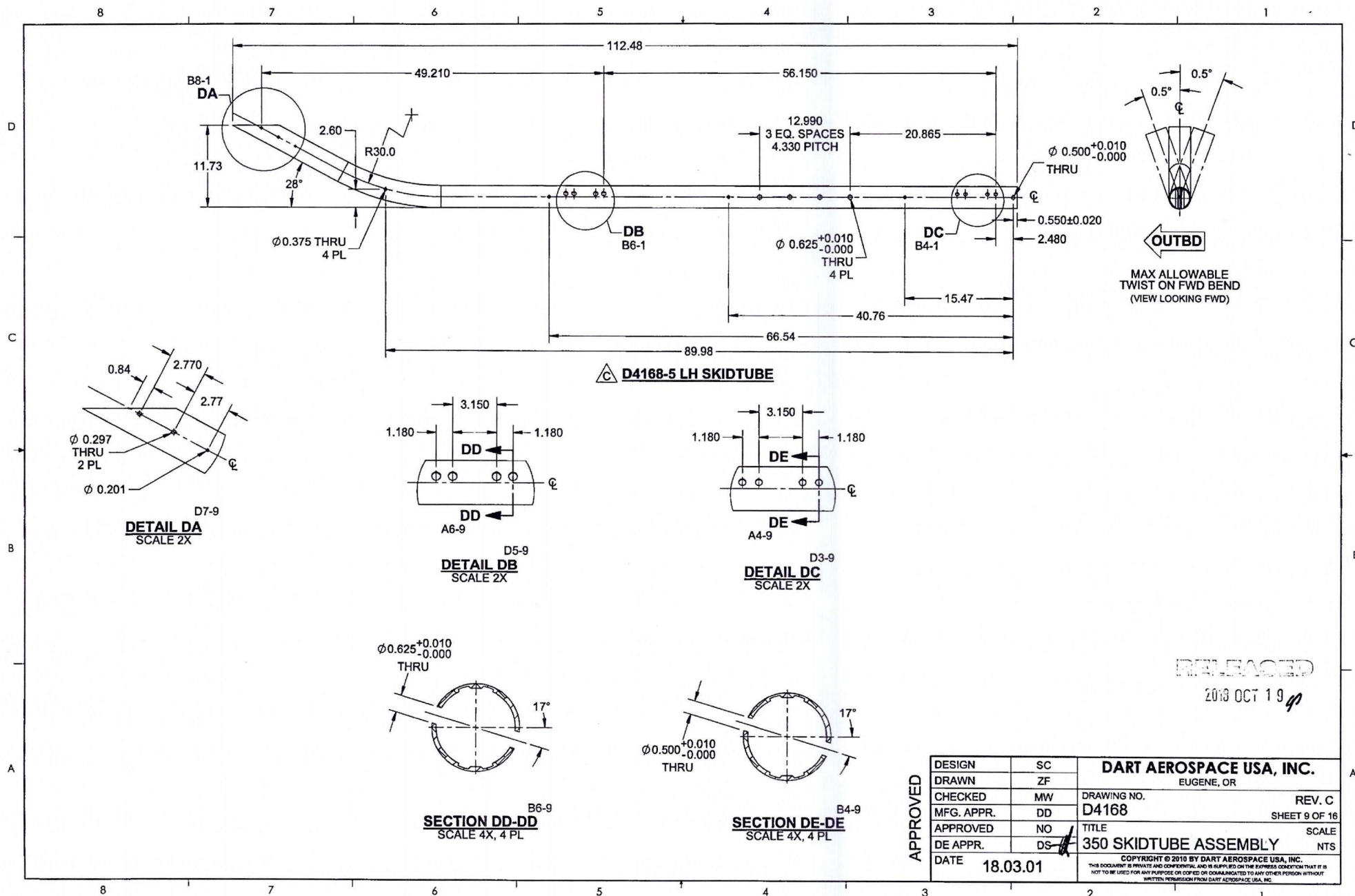


RELEASED
2013 OCT 19



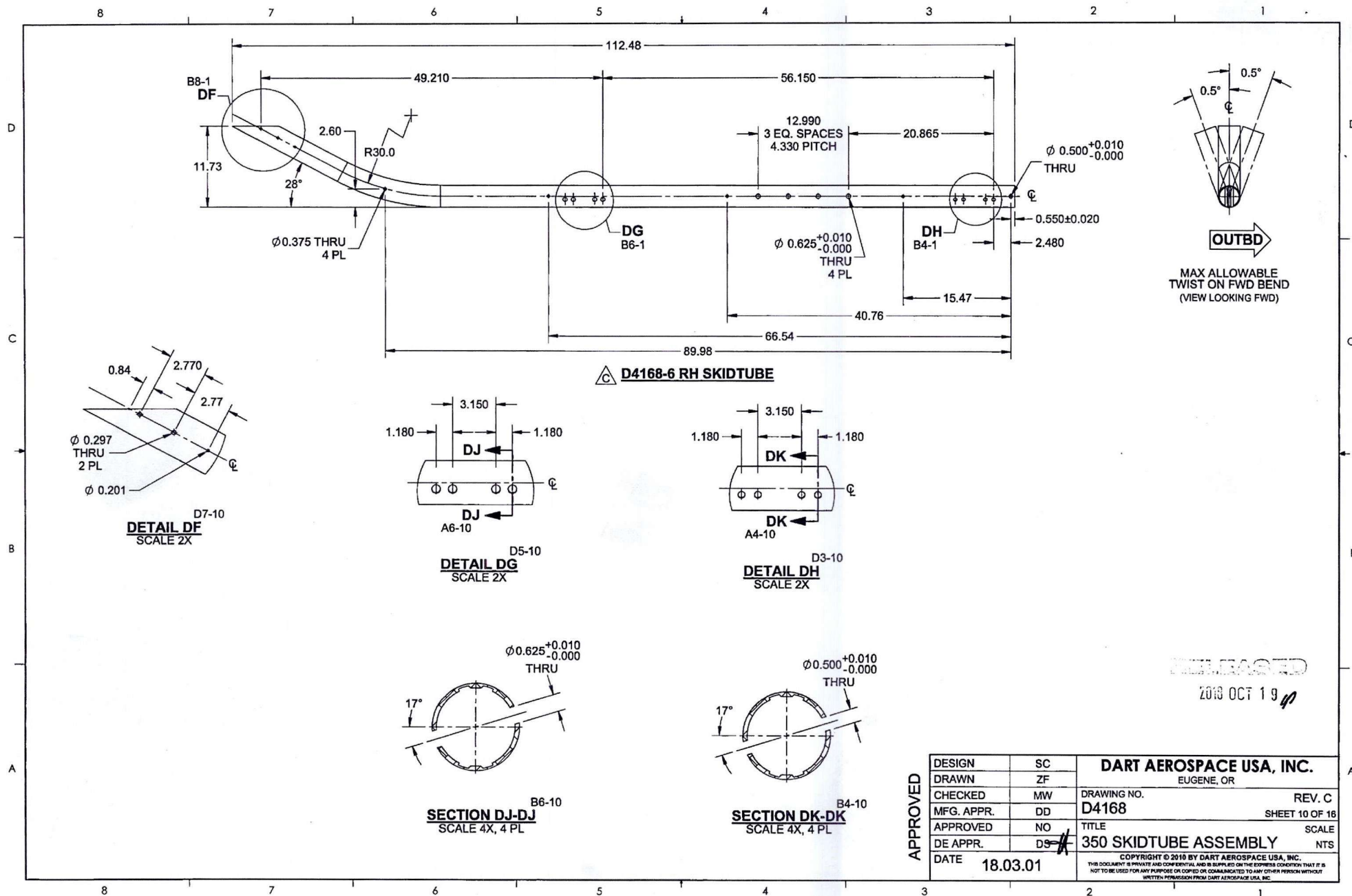
DESIGN	SC	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE, OR
CHECKED	MM	
MFG. APPR.	DD	
APPROVED	NO	
DATE	18.03.01	
TITLE	350 SKID TUBE ASSEMBLY	
DE APPR.	DS	
SCALE	NTS	

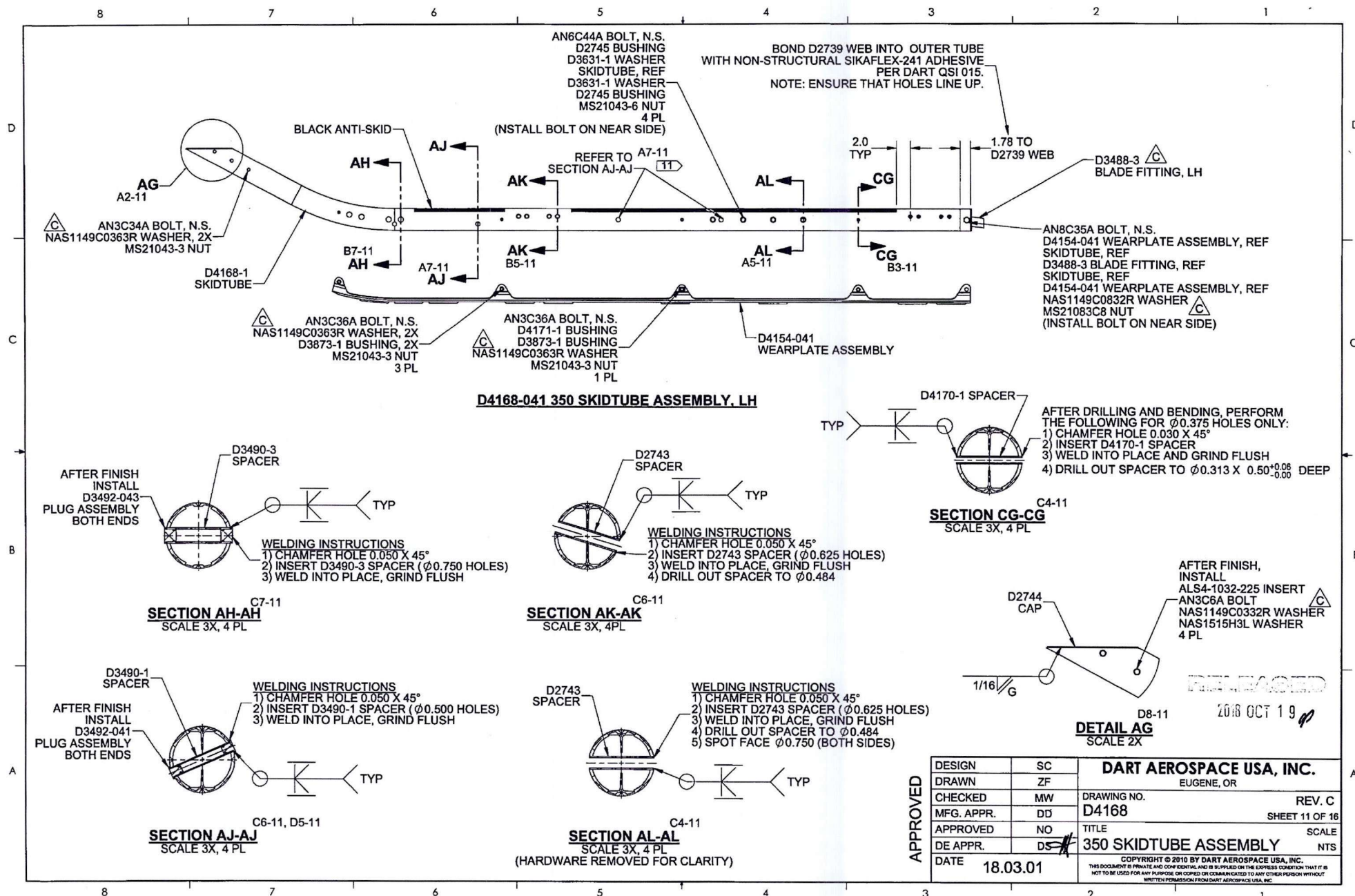
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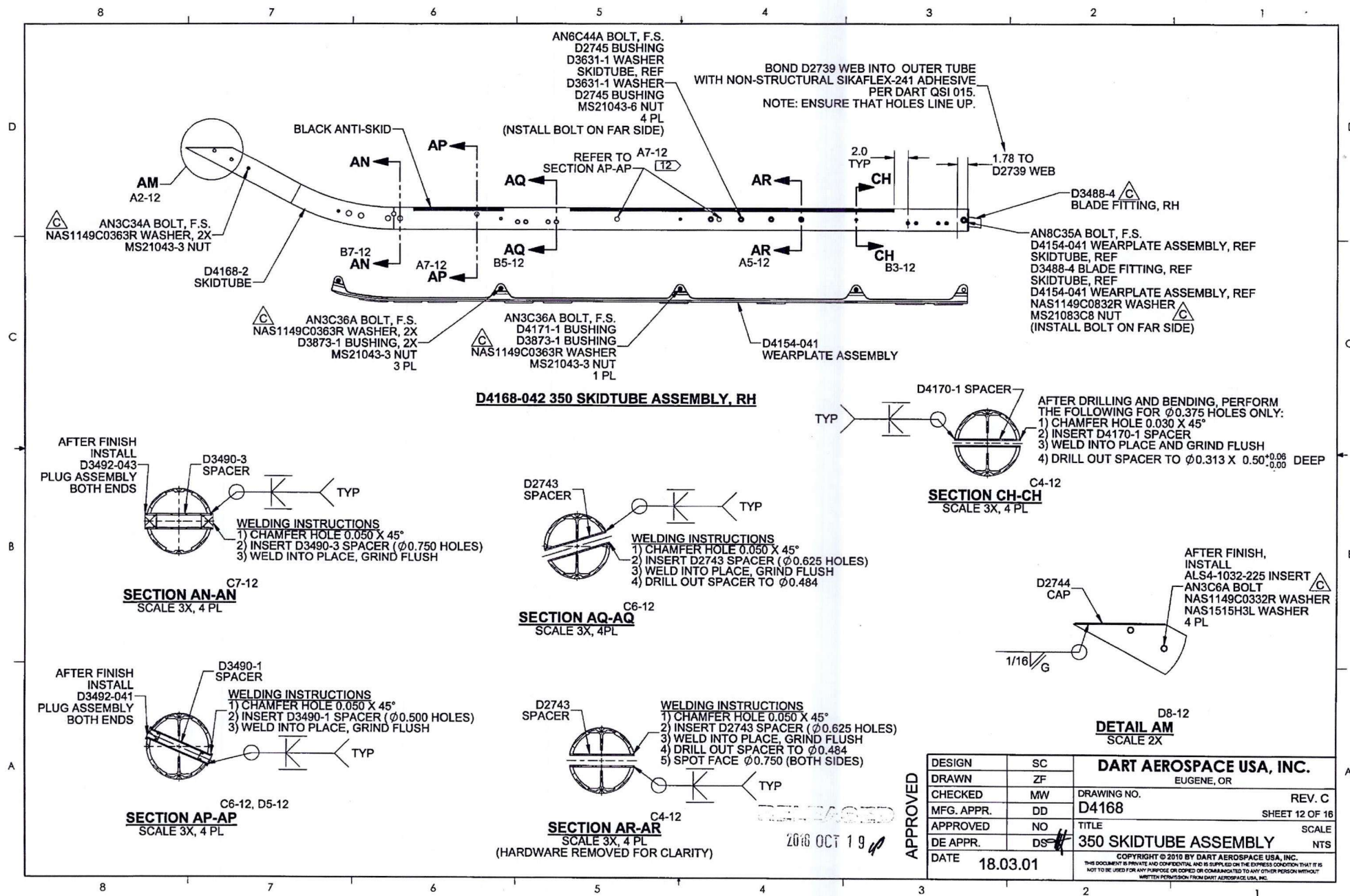


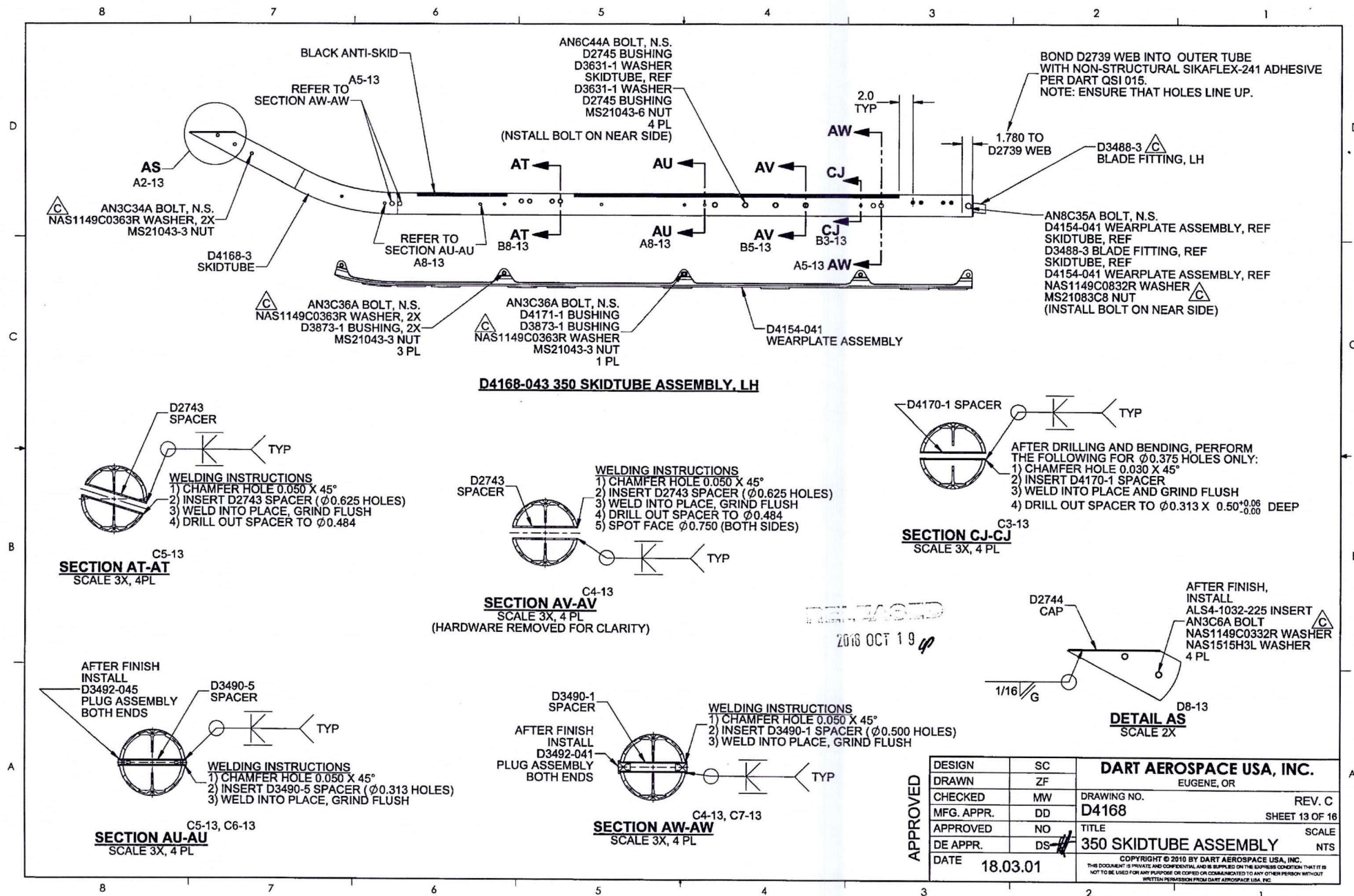
RELEASED

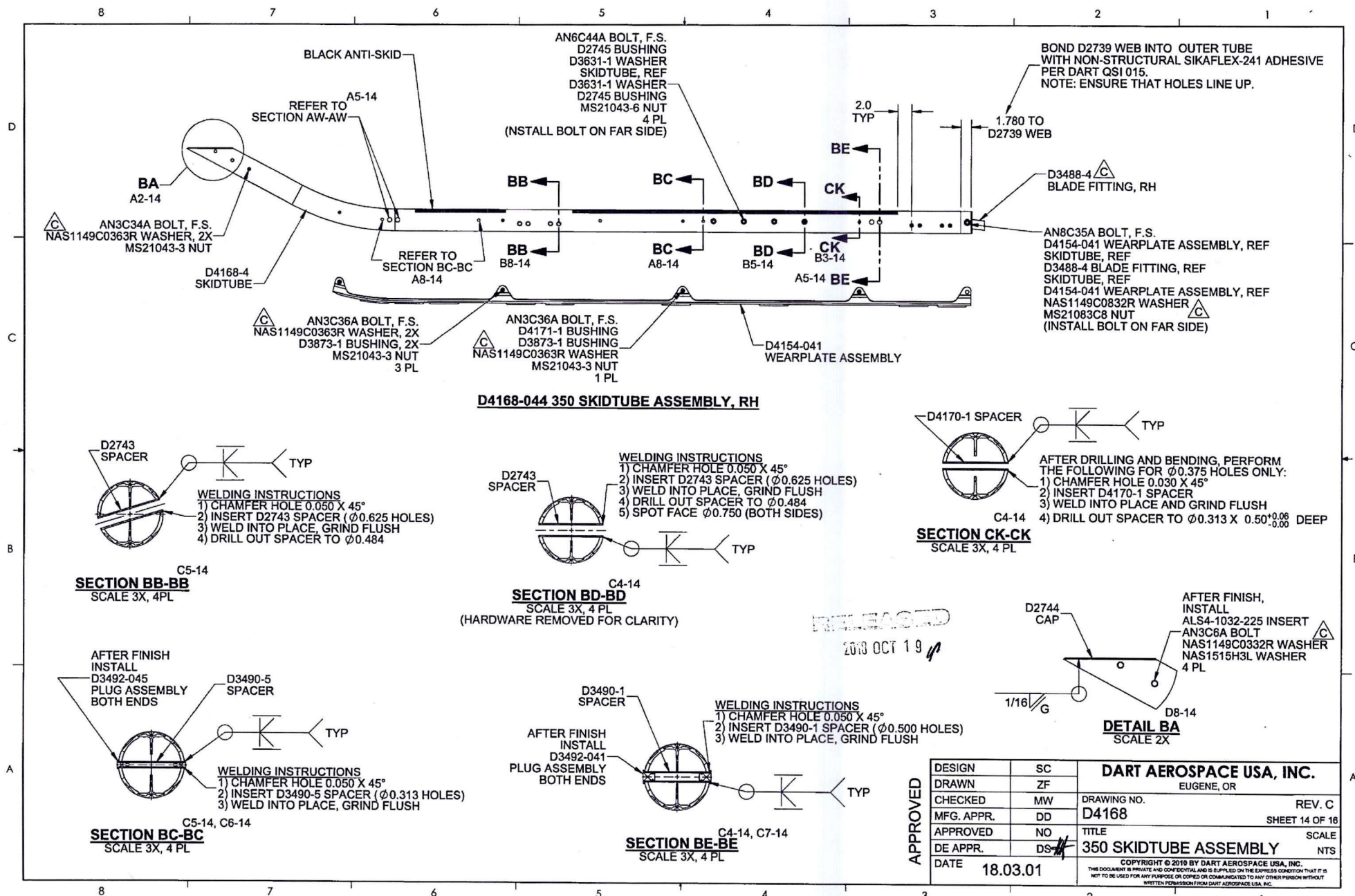
2010 OCT 19

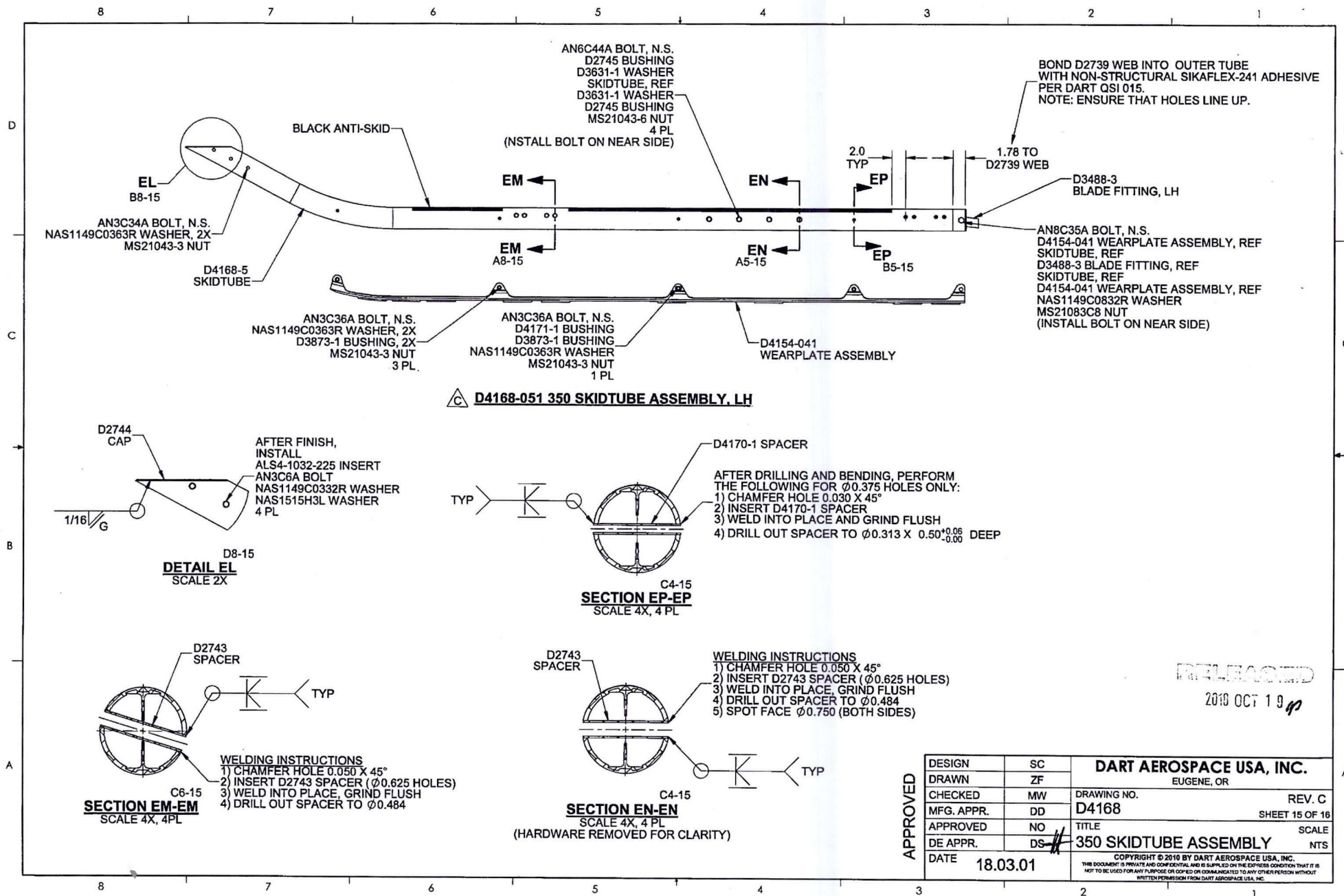


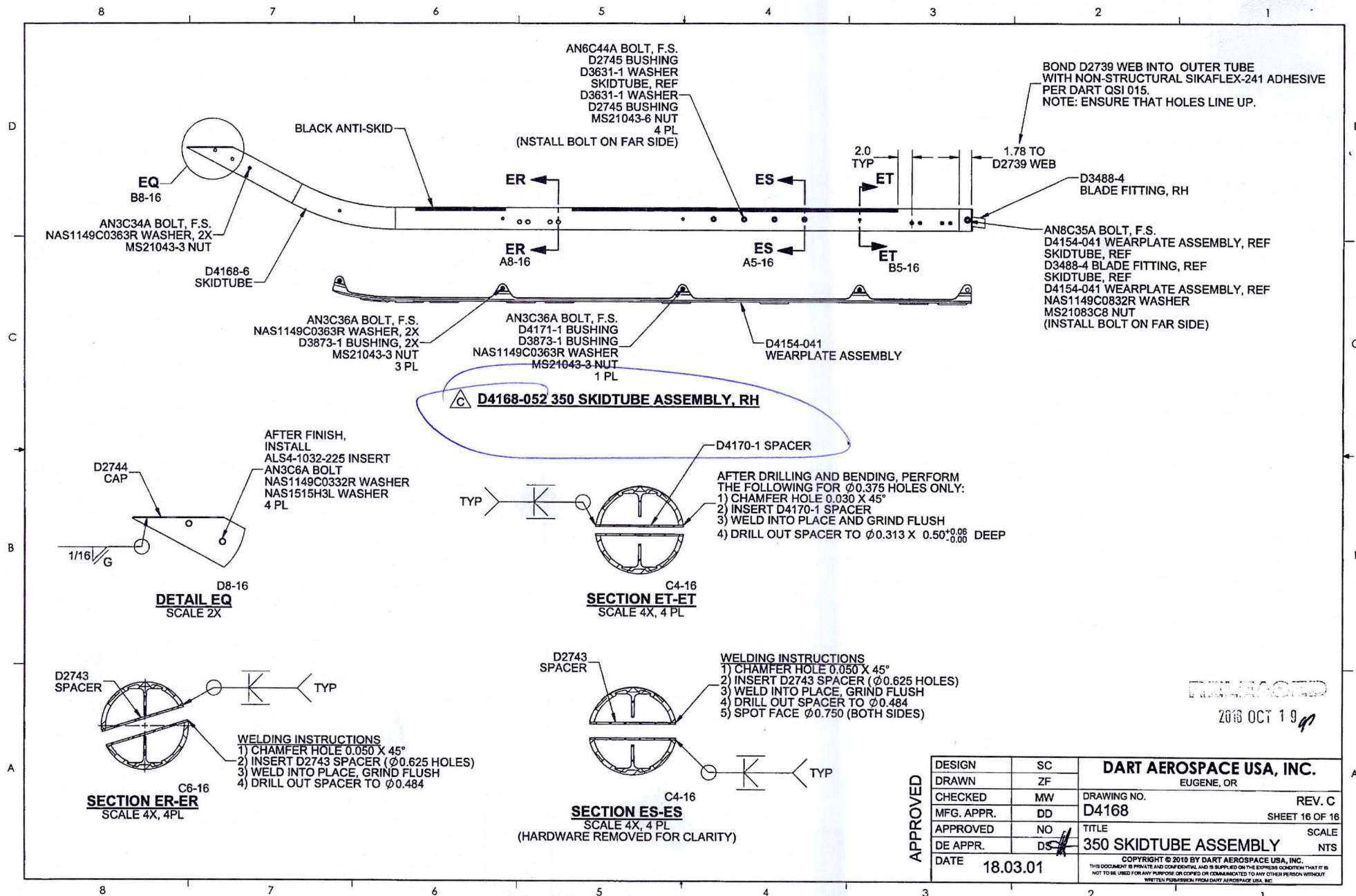












Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

AEROSPACE

5774641

420-064

12.10.2009

199710-11

... 2, EASA SIC

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149CO863J	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

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Revision: K

Date: 18.04.04

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS

² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS

³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

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Revision: **K**
Date: 18.04.04

Change Record

PAGE 1 OF 1

Part Number: D350-636-023/-024

Description: SKIDTUBE INSTALLATION LH/RH, STD COMPATIBLE W/TRAINING WEARPLATI

[illegible]